



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D4278-041**  
**Job Sheet 190991**



**Part No:** D4278-041

**Job Qty:** 2 pcs

**Part Name:** Upper Rib Assembly-Hoop



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 2/20/19

**Job Tracking No:**

**Due Date:** 3/8/19

**Created By:** Marie Lajeunesse

**Type:** SOLD

**Description:**

**Note:** DWG REV C SHEET 2 IPP Rev:A 10.11.12 new issue DD verf:EC IPP Rev:B 11.01.20 AS PER DWG REV.C DD verf:EC

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation                 | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|---------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                           |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 100   | Large Fab - Welded Assy-1 | 2 pcs | 3/8/19     | 3/8/19   | 0.00      | 2.82    | Large Fab - 1         |           |          |
|       |                           |       |            |          |           |         | Large Fab - 10        |           |          |
|       |                           |       |            |          |           |         | Large Fab - 2         |           |          |
|       |                           |       |            |          |           |         | Large Fab - 3         |           |          |
|       |                           |       |            |          |           |         | Large Fab - 4         |           |          |
|       |                           |       |            |          |           |         | Large Fab - 5         |           |          |
|       |                           |       |            |          |           |         | Large Fab - 6         |           |          |
|       |                           |       |            |          |           |         | Large Fab - 7         |           |          |
|       |                           |       |            |          |           |         | Large Fab - 8         |           |          |
|       |                           |       |            |          |           |         | Large Fab - 9         |           |          |
| 110   | QC 9                      | 2 pcs | 3/8/19     | 3/8/19   | 0.00      | 0.00    | QC 9 - 10             |           |          |
|       |                           |       |            |          |           |         | QC 9 - 18             |           |          |
|       |                           |       |            |          |           |         | QC 9 - 24             |           |          |
|       |                           |       |            |          |           |         | QC 9 - 43             |           |          |
|       |                           |       |            |          |           |         | QC 9 - 50             |           |          |
|       |                           |       |            |          |           |         | QC 9 - 9              |           |          |
| 120   | QC 5                      | 2 pcs | 3/8/19     | 3/8/19   | 0.00      | 0.00    | QC 5 - 10             |           |          |
|       |                           |       |            |          |           |         | QC 5 - 12             |           |          |
|       |                           |       |            |          |           |         | QC 5 - 17             |           |          |
|       |                           |       |            |          |           |         | QC 5 - 18             |           |          |
|       |                           |       |            |          |           |         | QC 5 - 19             |           |          |
|       |                           |       |            |          |           |         | QC 5 - 22             |           |          |
|       |                           |       |            |          |           |         | QC 5 - 24             |           |          |
|       |                           |       |            |          |           |         | QC 5 - 3              |           |          |
|       |                           |       |            |          |           |         | QC 5 - 42             |           |          |
|       |                           |       |            |          |           |         | QC 5 - 43             |           |          |
|       |                           |       |            |          |           |         | QC 5 - 49             |           |          |
|       |                           |       |            |          |           |         | QC 5 - 51             |           |          |
|       |                           |       |            |          |           |         | QC 5 - 58             |           |          |
|       |                           |       |            |          |           |         | QC 5 - 68             |           |          |
|       |                           |       |            |          |           |         |                       |           |          |

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|                                       |        |           |                        |  |
|---------------------------------------|--------|-----------|------------------------|--|
| 130 Packaging 3-1 - Stock - B4B 2 pcs | 3/8/19 | 0.00 0.00 | QC 5 - 9               |  |
|                                       |        |           | QC 5 - 50              |  |
|                                       |        |           | QC 5 - 30              |  |
|                                       |        |           | Packaging 3 - 1 - B4B  |  |
|                                       |        |           | Packaging 3 - 2 - B4B  |  |
|                                       |        |           | Packaging 3 - 3 - B4B  |  |
|                                       |        |           | Packaging 3 - 4 - B4B  |  |
|                                       |        |           | Packaging 3 - 5 - B4B  |  |
|                                       |        |           | Packaging 3 - 6 - B4B  |  |
|                                       |        |           | Packaging 3 - 7 - B4B  |  |
|                                       |        |           | Packaging 3 - 8 - B4B  |  |
|                                       |        |           | Packaging 3 - 9 - B4B  |  |
|                                       |        |           | Packaging 3 - 10 - B4B |  |
|                                       |        |           | Packaging 3 - 11 - B4B |  |
|                                       |        |           | Packaging 3 - 12 - B4B |  |
|                                       |        |           | Packaging 3 - 13 - B4B |  |
|                                       |        |           | Packaging 3 - 14 - B4B |  |
|                                       |        |           | Packaging 3 - 15 - B4B |  |
|                                       |        |           | Packaging 3 - 16 - B4B |  |
|                                       |        |           | Packaging 3 - 17 - B4B |  |
|                                       |        |           | Packaging 3 - 18 - B4B |  |
|                                       |        |           | Packaging 3 - 19 - B4B |  |
|                                       |        |           | Packaging 3 - 20 - B4B |  |
|                                       |        |           | Packaging 3 - 21 - B4B |  |
|                                       |        |           | Packaging 3 - 22 - B4B |  |
|                                       |        |           | Packaging 3 - 23 - B4B |  |
|                                       |        |           | Packaging 3 - 24 - B4B |  |
|                                       |        |           | Packaging 3 - 25 - B4B |  |
|                                       |        |           | Packaging 3 - 26 - B4B |  |
|                                       |        |           | Packaging 3 - 27 - B4B |  |
|                                       |        |           | Packaging 3 - 28 - B4B |  |
|                                       |        |           | Packaging 3 - 29 - B4B |  |
|                                       |        |           | Packaging 3 - 30 - B4B |  |
|                                       |        |           | Packaging 3 - 31 - B4B |  |
|                                       |        |           | Packaging 3 - 32 - B4B |  |
|                                       |        |           | Packaging 3 - 33 - B4B |  |
|                                       |        |           | Packaging 3 - 34 - B4B |  |
|                                       |        |           | Packaging 3 - 35 - B4B |  |
|                                       |        |           | Packaging 3 - 36 - B4B |  |
| 140 QC 21 - SA                        | 3/8/19 | 0.00 0.00 | QC 21 - SA - 21        |  |
|                                       |        |           | QC 21 - SA - 70        |  |
|                                       |        |           | QC 21 - SA - 53        |  |

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DAS  
24  
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21  
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Part Op 100 - Weld per dwg A/R S.S. rod Batch: 136920 - Assemble ribs to hoop and weld as per dwg using jig DT9564  
 Descriptions: 110 - (QC9- Inspect visual per QSI004- Fusion Welds)  
 120 - (QC5- Inspect part completeness to step on W/O)  
 130 - (Identify as per dwg & Stock Location: \_\_\_\_\_) \*\*\*STOCK IN BASKET CELL\*\*\*  
 140 - (QC21- Final Inspection - Work Order Release)

WAD04-4

## Job BOM

| Part / Item | Component Name | Quantity     | Operation                     | Container |
|-------------|----------------|--------------|-------------------------------|-----------|
| D4021-7     | Hoop           | 2 pcs (1 ea) | 100-Large Fab - Welded Assy-1 | 5150285   |
| D4021-9     | Bushing        | 8 pcs (4 ea) | 100-Large Fab - Welded Assy-1 | 5115310   |
| D4034-1     | Rib            | 2 pcs (1 ea) | 100-Large Fab - Welded Assy-1 | 5160156   |
| D4034-3     | Rib            | 2 pcs (1 ea) | 100-Large Fab - Welded Assy-1 | 5159634   |

| Job Allocations                    |                |          |           |           |
|------------------------------------|----------------|----------|-----------|-----------|
| Operation                          | Component Part | Required | Inventory | Allocated |
| 100-Large Fab - Welded Assy-1      | D4021-7        | 2        | 26        | 0         |
|                                    | D4021-9        | 8        | 203       | 0         |
|                                    | D4034-1        | 2        | 17        | 0         |
|                                    | D4034-3        | 2        | 15        | 0         |
| Part Specifications                |                |          |           |           |
| Specifications could not be found. |                |          |           |           |

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

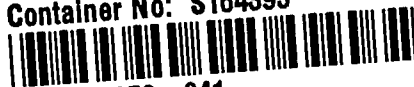
NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                        |  |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                      |  |                        |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  | MRB (QSI042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                        |  |
| <b>Root Cause</b><br><br><div style="display: flex;"> <div style="flex: 1;">           Operator <input type="checkbox"/><br/>           Manufacturing Process <input type="checkbox"/><br/>           Equip/Tooling <input type="checkbox"/><br/>           Handling/Preservation <input type="checkbox"/><br/>           Material <input type="checkbox"/><br/>           Product Improvement <input type="checkbox"/><br/>           Process Improvement <input type="checkbox"/><br/>           Human Factors <input type="checkbox"/> </div> <div style="flex: 1;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex;"> <div style="flex: 1;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="flex: 1;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="flex: 1;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                        |  |



Container No: S164395



Part: D4278-041

Job No: 190991

Serial No/Batch: S164395

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 813 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

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